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D3642-1**Job Sheet 191506****Part No:** D3642-1**Job Qty:** 12 pcs**Part Name:** Doubler**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 3/4/19**Job Tracking No:****Due Date:** 3/22/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV B IPP Rev:A New Issue 07-07-20 JLM Verified By:EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		3/22/19	0.00	1.08	Waterjet - Flow		OK 19/03/19
110	QC 2	12 pcs		3/22/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		OK 19/03/19
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		

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					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 6	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
						MAR 2 1 2019
						DAS 40 9-89
150	Packaging 3-1 - Stock - B4B	12 pcs	3/22/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	5+046 8 MAR 2 1 2019
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
160	QC 21 - SA	12 pcs	3/22/19	0.00 0.00	QC 21 - SA - 21	DAS 21 9-89
					QC 21 - SA - 70	
					QC 21 - SA - 53	
Part Op 110 - (QC2- Inspect parts off machine FAI/FAIB) Descriptions: 120 - (QC8- Inspect parts - second check) 130 - (Chemical Conversion Coat per QSI005 4.1)						

MAR 21 2019
DAS
40
9-89

5+046 81 MAR 21 2019

DAS
21 MAR 22 2019
9-89

140 - (QC3- Inspect Part Finish)

150 - (Identify as per dwg & Stock Location: _____)

160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	1.9968 sf (.1664 ea)	100-Waterjet - Flow - 1	S155269 315215050 5099479

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.050	2	48	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order: 191508
Description: Doubler		Part Number: D3642-1
Inspection Dwg: D3642	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.125	+0.004/-0.001	Ø.124	1		V-D-02	
Ø0.098	+0.004/-0.001	Ø.099	1		T-p	
0.35	+/-0.030	.35	1			
1.25	+/-0.030	1.25	1			
1.700	+/-0.010	1.702	1			
2.15	+/-0.030	2.15	1			
3.05	+/-0.030	3.05	1			
3.95	+/-0.030	3.95	1			
4.078	+/-0.010	4.079	1			
4.85	+/-0.030	4.85	1			
5.20	+/-0.030	5.20	1			
0.343	+/-0.010	.345	1			
0.40	+/-0.030	.40	1			
1.30	+/-0.030	1.30	1			
3.35	+/-0.030	3.35	1			
3.47	+/-0.030	3.47	1			
3.79	+/-0.030	3.79	1			
3.959	+/-0.010	3.961	1			
4.08	+/-0.030	4.08	1			
4.60	+/-0.030	4.60	1			
1.537	+/-0.010	1.539	1			
3.28	+/-0.030	3.28	1			
3.80	+/-0.030	3.80	1			
3.915	+/-0.010	3.917	1			
0.450	+/-0.010	.451	1			
4.066	+/-0.010	4.067	1			
4.20	+/-0.030	4.20	1			

Measured by: dx	Audited by: DAS 40	Prototype Approval:	N/A
Date: 19/03/19	Date: MAR 20 2019	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	
B	08.12.01	Dimensions updated per Dwg Rev. B	KJ/EC	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S163892



Part: D3642-1

Job No: 191506

Serial No/Batch: S163892

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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